



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5520-1
Job Sheet 172882



Part No: D5520-1

Job Qty: 32 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No: Reference SO 3501

Due Date: 3/12/18

Created By: Michelle Gagnon-Donovan

Type: **SOLD**

Description:

Note: DWG D5520 REV.A IPP REV:A 17.05.12 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		3/9/18	0.00	0.00	Start Up Waterjet		<u>ae 18/02/2018</u>
100	Waterjet	20 pcs		3/10/18	0.00	2.50	Waterjet1		<u>ae 18/02/2018</u>
110	QC	20 pcs		3/10/18	0.00	0.00	QC2 Waterjet-4		<u>a 18/02/2018</u>
120	QC	20 pcs		3/10/18	0.00	0.00	QC8-6		<u>ae</u>
130	Brake NC	20 pcs		3/10/18	0.00	1.33	Brake NC 1		<u>SB DAS</u>
140	QC	20 pcs		3/10/18	0.00	0.00	QC5		<u>38</u>
150	HandFinish	20 pcs		3/10/18	0.00	1.00	HandFinish1		<u>SADAS 18-03-07</u>
160	QC	20 pcs		3/10/18	0.00	0.00	QC7-5		<u>38</u>
170	SprayPaint	20 pcs		3/12/18	0.00	3.33	Spray Paint		<u>AS 11 MAR 1 1 2018</u>
180	QC	20 pcs		3/12/18	0.00	0.00	QC3		<u>11 MAR 1 2 2018</u>
190	Packaging	20 pcs		3/12/18	0.00	0.00	Packaging3-2		<u>DAG-89</u>
200	QC21-SA	20 Ea		3/12/18	0.00	0.00	QC21		<u>21 MAR 1 2 2018</u>

Part Op 100 - 1-Cut as per Dwg ***VERIFY GRAIN DIRECTION*** Dwg Rev: A Prog Rev: A 925 Debur if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - FORM TO CORRECT RAD AS PER DWG "USE THE INSIDE EXTRUSION D2962 FOR FIT TEST"

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - Prime as per Dart QSI 005 4.2 Primer Batch: 137670

180 - QC3- Inspect Part Finish

190 - Identify as per dwg & Stock Location: _____

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.188	6061-T6 .188 Sheet	3.3200 sf (.166 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.188	3	22	0

Part Specifications

Specifications could not be found.



Container No: S045659



Part: D5520-1

Job No: 172882

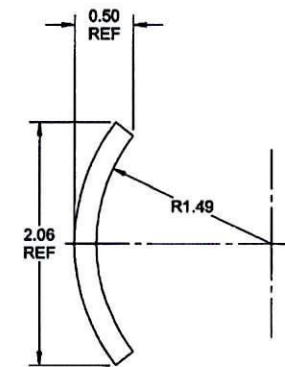
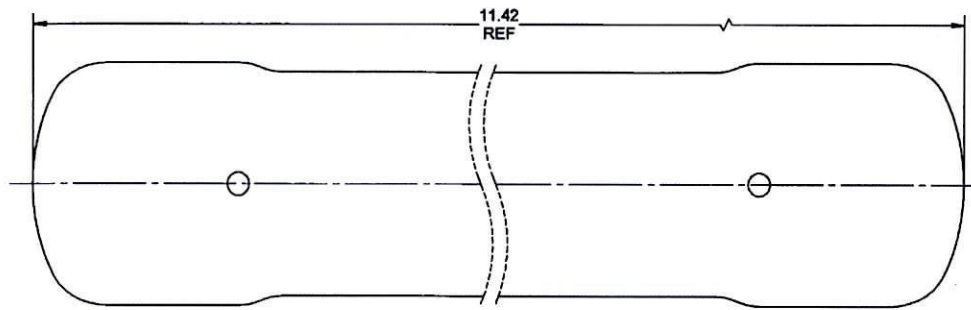
Serial No/Batch: S045659

Revision: D5520

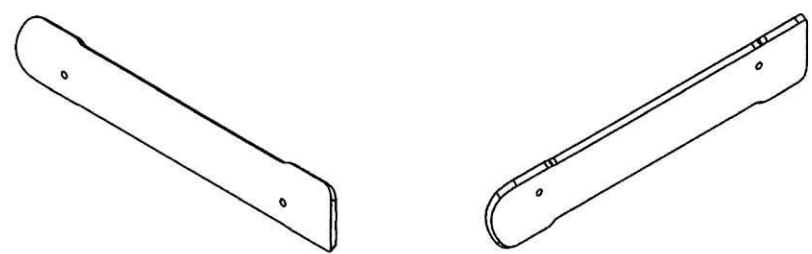
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/26/18



D5520-1 DOUBLER
(BEND DETAIL)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 172882

FEB 23 2018

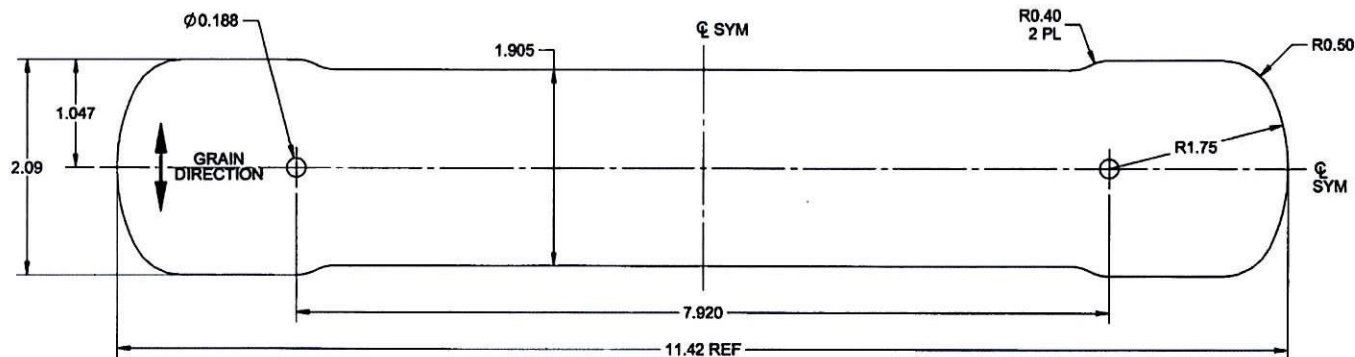
- NOTES:
- 1) MATERIAL: MAKE FROM D5520-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.40 lbs

RELEASED
2017-08-11
EW 17-547

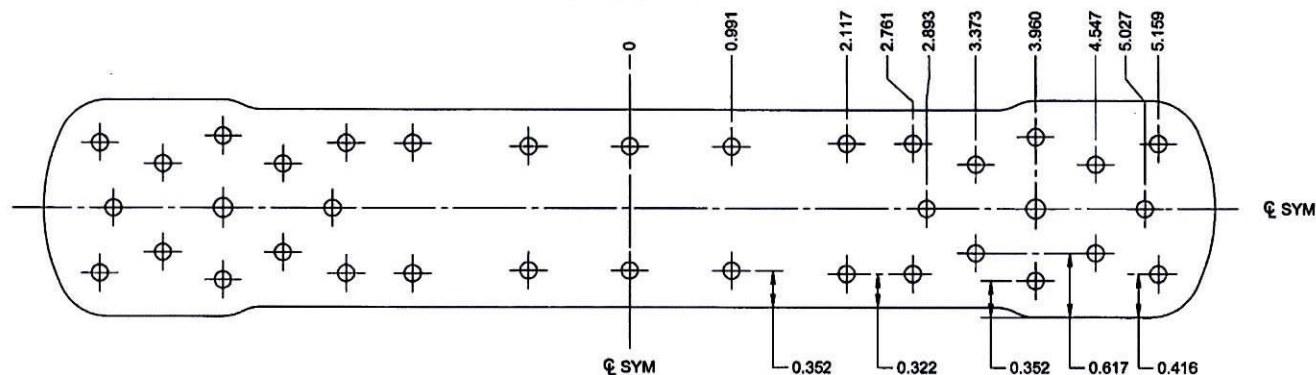
APPROVED

APPROVED

A		NEW ISSUE (NCR17-6303)		ML	17.03.09
REV.		DESCRIPTION		BY	DATE
DESIGN	ML	DART AEROSPACE USA, INC EUGENE, OR			
DRAWN	AJS				
CHECKED	ML	DRAWING NO. D5520		REV. A	SHEET 1 OF 2
MFG. APPR.	DP	TITLE DOUBLER		SCALE	
APPROVED	WM	DATE 17.03.09		NTS	
DE APPR.	DS				
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D5520-1F DOUBLER
(FLAT PATTERN)



D5520-1F DOUBLER

+ REPRESENTS THE LOCATION OF RIVET HOLES
TO BE DRILLED ON INSTALLATION
(HOLES SHOWN AS REFERENCE ONLY)

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR/SHEET, 0.188 THICK
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4180)
OR ASTM B211 OR ASTM B221 OR QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6B0.188 OR M6061T6S0.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs
- 8) DRILL HOLES USING DT10309

RELEASED
2017-08-11

APPROVED

DESIGN	ML
DRAWN	AJS
CHECKED	ML
MFG. APPR.	DP
APPROVED	WM
DE APPR.	DS
DATE	17.03.09

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO.
D5520
REV. A
SHEET 2 OF 2
TITLE
DOUBLER
SCALE
NTS

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